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008324

D407-547-047
Job Sheet 187945



Part No: D407-547-047

Job Qty: 1 pcs

Part Name: Console High Slope



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/21/18

Job Tracking No:

Due Date: 1/16/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D206-547 REV F Sheet 1,5 IPP Rev:I 06-01-05 Removed Packing Kit JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	1/16/19		0.00	0.93	Small Fab - 1		DAS 58 FEB 26 2019 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
130	QC 5	1 pcs	1/16/19		0.00	0.00	QC 5 - 10		DAS 68 FEB 26 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
140	Large Fab - Welded Assy-2-B4B	1 pcs	1/16/19		0.00	0.39	Large Fab - 1 - B4B		JBC
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
150 QC 10	1 pcs	1/16/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 38	DAS
				QC 10 - 43	24
				QC 10 - 50	9-89
				QC 10 - 58	
				QC 10 - 9	
160 Small Fab - 2 - B4B	1 pcs	1/16/19	0.00 0.93	Small Fab - 1 - B4B	DAS
				Small Fab - 2 - B4B	51
				Small Fab - 3 - B4B	9-89
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
170 QC 5	1 pcs	1/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS
				QC 5 - 9	FEB 27 2019 68
				QC 5 - 50	9-89
				QC 5 - 30	
180 Powdercoat - 4 Black Sand -B4B	1 pcs	1/16/19	0.00 0.16	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	3/19-00-07
190 QC 3	1 pcs	1/16/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	DAS
				QC 3 - 9	FEB 27 2019 68

Entered: _____ Date: _____



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Other/Details:					

200 Packaging 3-1 - Stock - B4B	1 pcs	1/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
210 QC 21 - FG	1 pcs	1/16/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	

Entered: _____ Date: _____



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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Part Op 100 - (Small Fab) 1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates
 Descriptions: DT 8264-1, DT 8264-2, DT8264-3, DT8264-4 2-Deburr 3-Grind weld relief chamfer as per Dwg D206-547 4- Clean rails
 with ultra brigh aluminum cleaner before riveting 5- Rivet extrusion to sides as per Dwg D206-547 using Rivet
 MS20470AD3-4

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Weld as per Dwg D206-547 A/R AL ROD

Batch: _____ 2-Grind weld as per dwg D206-547

150 - (QC10- Inspect visual per QSI004- ground welds)

160 - (Small Fab) 1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Black Sandtex (Ref:4.3.5.7) per QSI005 4.3) START TIME: 10:00 OVEN TEMPERATURE: 320°

FINISH TIME: 10:30 M 138940

190 - (QC3- Inspect Part Finish)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2024	Extrusion (\$ Per Square Foot)	3.4200 ft (3.42 ea)	100-Small Fab - 1	<u>5047813</u>
D2604-1 <u>ST482</u>	Console Side LH, 407 Console	1 Ea (1 ea)	100-Small Fab - 1	<u>5155007</u>
D2604-2 <u>ST482</u>	Console Side RH, 407 Console	1 Ea (1 ea)	100-Small Fab - 1	<u>516650</u>
D2606 <u>ST008</u>	Console Bracket, 206/407 Console	1 Ea (1 ea)	100-Small Fab - 1	<u>5188297</u>
D2608 <u>ST008</u>	Bracket, 407 Console	1 pcs (1 ea)	100-Small Fab - 1	<u>5106678</u>
MS20470AD3-3	Rivet, Universal Head	6 Ea (6 ea)	100-Small Fab - 1	<u>Flow5</u>
MS20470AD3-4	Rivet, Universal Head	20 Ea (20 ea)	100-Small Fab - 1	<u>fm136851-1</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D2024	3	880	0
	D2604-1	1	0	0
	D2604-2	1	1	0
	D2606	1	2	0
	D2608	1	2	0
	MS20470AD3-3	6	6,149	0
	MS20470AD3-4	20	5,876	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date : _____	Container No: S156844 Part: D407 - 547 - 047 Job No: 187945 Serial No/Batch: S156844 Revision: F Inspector: _____ Exp Date: _____ Instructions: Various STC's DART Aerospace 1270 Aberdeen Street Hawkesbury, ON K6A 1K6 CANADA TEL: 1 613 632-5272 Email: sales@dartaero.com www.dartaero.com				MRB (QSI042)
Description					Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	Surge ☐ n ☐ on ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
	Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		
	Other/Details: _____				